

Work Order ID 67826 - 2



Page 1

Thursday, March 31, 2011 1:19:16 PM

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 3/31/2011

Start Qty: 100.00

Required Date: 4/15/2011

Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date: 11/03/31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



Bandsaw

Jesper Bandsaw

BAND SAW

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch

Cut @ Metec

CZ 11/03/31 100

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

1-Machine per folio HA927

DWG REV

FOLIO REV

(Check for crack while loading into the machine.)

2- deburr rough edges

P/O: 13764

CZ 11/03/31 100

issue P/O to metec

machine as per drawing D2230 REV.G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67826

Thursday, March 31, 2011 1:19:16 PM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC Inspect parts off machine FAI/FAIB

0.00



QC
Quality Control

Memo

0.00

read + inspect for transit damage
attached CAFE to W/O

4/1/05 (85)

130

QC Inspect parts - second check

0.00



QC
Quality Control

Memo

0.00

Subline

counter
(85)
QSPAS

140

Chemical Conversion Coat per QSI005 4.1

0.00



Hand Finish
Hand Finishing

Memo

0.00

7m, L 11/05/02 (85X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, March 31, 2011 1:19:16 PM



Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SS 11/05/02

160

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M116 964

Memo

0.00

Powder Coating

START TIME: 8:30
OVEN TEMPERATURE 320°
FINISH TIME: 9:00

SS BR 11-5-4

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SS 11/5/4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67826

Thursday, March 31, 2011 1:19:16 PM



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Accept



Setup Start



Revision ID:

Stop



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Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

Identify as per dwg & Stock Location ST 76

0.00



Packaging

Memo

0.00

Packaging

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

EP 11/05/09 (85)

11/5/09

11-05-9 (85)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 1:19:12 PM

Page 1

Work Order ID: 67826

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 3/31/2011

Required Date: 4/15/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D 00.11.01' Added inspection level 8. and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	384.5000	0.0683	7.189474			



Lug Extrusion



C211/03/31

Location

Loc Qty

Loc Code

MA1006

384.5

43722

161.5

45800

1

63005

222

719

D2230-1P

X100

C41/4/25 (85)

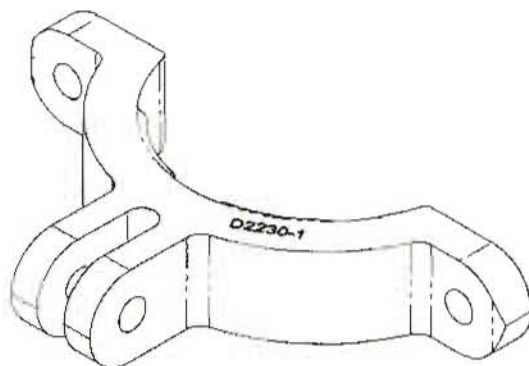
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

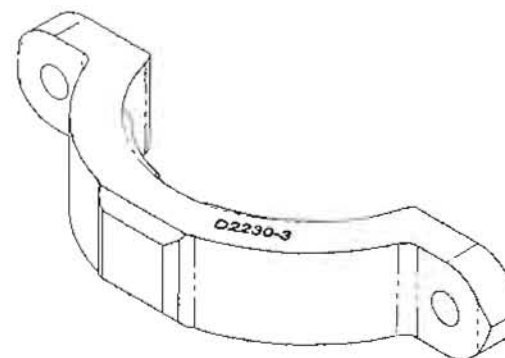
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/05/16

C211/03/31

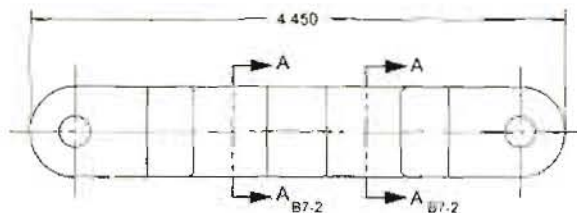
W10.67826



NOTES

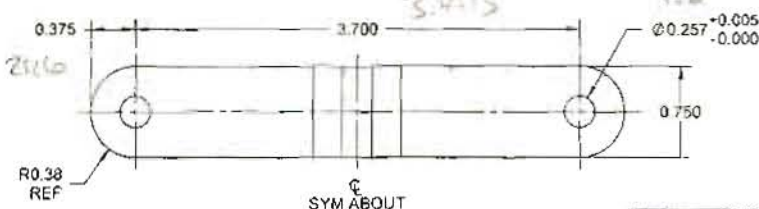
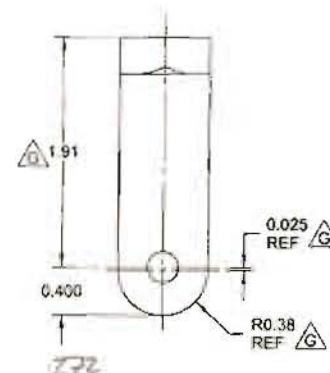
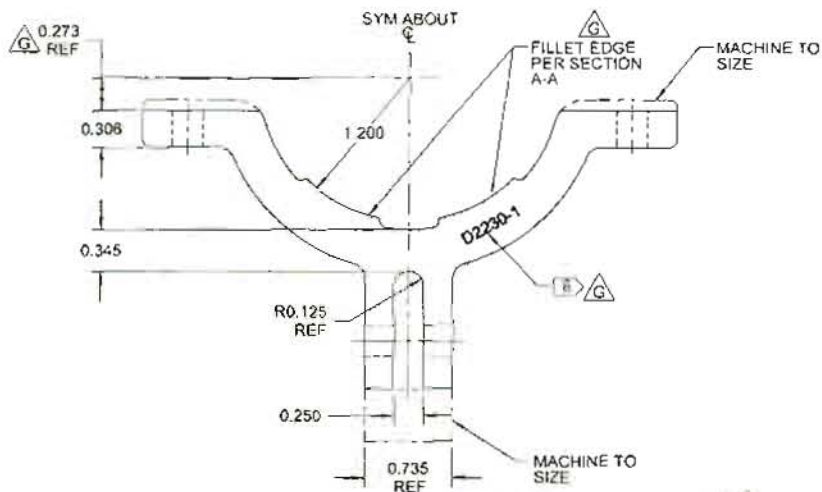
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT: -5: 0.15 lbs
-3: 0.14 lbs

REV	DESCRIPTION	BY	DATE																										
G	REDESIGN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16																										
F	REDESIGN: R1.200 WAS 1.100	CP	09.12.13																										
E	RE-DESIGN	BW	05.01.04																										
D	RE-DESIGN	BW	05.01.04																										
C	RE-DESIGN	BW	04.03.00																										
<table border="1"> <tr> <td>DESIGN</td><td>BW</td><td colspan="2" rowspan="2"> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA </td></tr> <tr> <td>DRAWN</td><td>AJS</td></tr> <tr> <td>CHECKED</td><td></td><td>DRAWING NO</td><td>REV. G</td></tr> <tr> <td>MFG APPR</td><td></td><td>D2230</td><td>SHEET 1 OF 3</td></tr> <tr> <td>APPROVED</td><td></td><td>TITLE</td><td>SCALE</td></tr> <tr> <td>DE APPR</td><td></td><td>MOUNTING LUG</td><td>NTS</td></tr> <tr> <td>DATE</td><td>09.01.16</td><td colspan="2"> <small> COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED, UNCONTROLLED, AND IS NOT TO BE DISTRIBUTED OUTSIDE THE DART AEROSPACE LTD. FACILITY. IT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. </small> </td></tr> </table>				DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWN	AJS	CHECKED		DRAWING NO	REV. G	MFG APPR		D2230	SHEET 1 OF 3	APPROVED		TITLE	SCALE	DE APPR		MOUNTING LUG	NTS	DATE	09.01.16	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED, UNCONTROLLED, AND IS NOT TO BE DISTRIBUTED OUTSIDE THE DART AEROSPACE LTD. FACILITY. IT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. </small>	
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SECTION A-A D4-2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



W10.67826

D2230-1 MOUNTING LUG

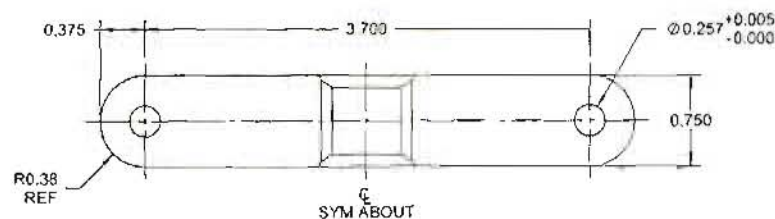
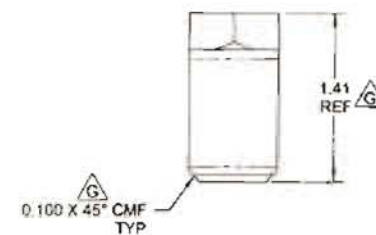
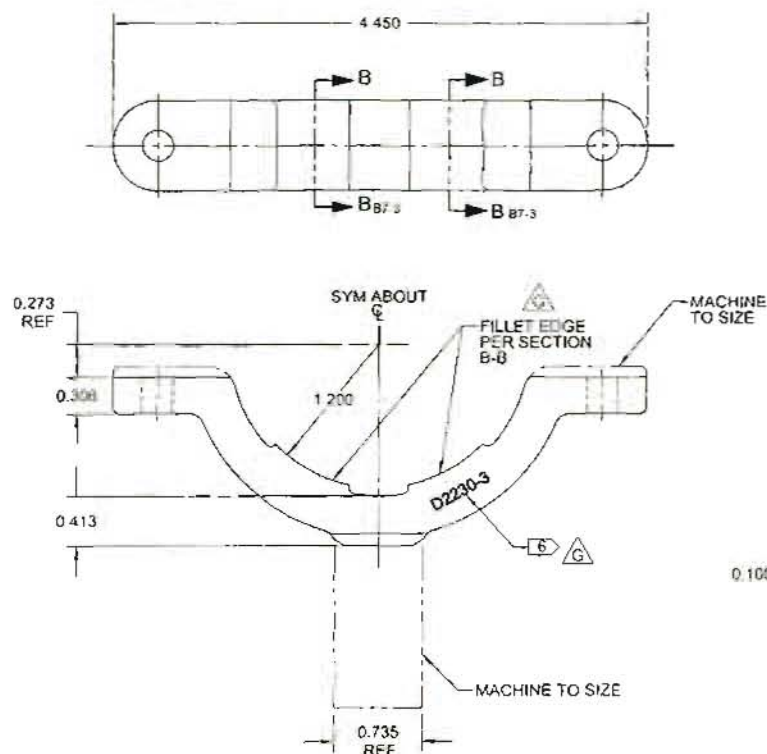
RELEASED
07/06/75

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. G
MFG APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1999 BY DART AEROSPACE LTD	

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2230	REV. G
MFG APPR.		TITLE	SHEET 3 OF 3
APPROVED		MOUNTING LUG	SCALE
DE APPR			NTS
DATE	09.01.16	COPYRIGHT © 1998 BY DART AEROSPACE LTD.	

W10.67826



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13764

Purchase Order Date 3/31/2011

PO Print Date 4/6/2011

Page Number 1 of 1

Order From :
METEC METAL TECHNOLOGY INC.
10 TERRY FOX DRIVE PO BOX 781
WANKLEEK HILL, QC K0B 1R0
CANADA

VC-MET003

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

RECEIVED

Order To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2230-1P		LUG	4/22/2011 Yes	100.00 Each	Dart Truck Net 55	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67826				
D2230-3P		LUG	4/22/2011 Yes	100.00 Each	Dart Truck Net 55	\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67827				
D3235-1P		lug	4/22/2011 Yes	100.00 Each	Dart Truck Net 55	\$15.0500	\$1,505.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B67831				
PO Total:							\$4,760.00

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 4/6/2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17924
Date: Apr 25, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13764	Sold By:
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	85	15
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

85

D3910-1

Lug

13764

MATERIAL supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shig Walz

Vankleek Hill, April 25, 2011

